

Work Order ID 68449

Wednesday, April 13, 2011 2:54:23 PM



PRELIMINARY ISSUE

Page 1

Item ID:	D4375-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Bracket Assembly, LH					
Start Date:	4/13/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/18/2011	Req'd Qty:	1.00		Customer:	
Reference:						



Approvals:	Process Plan:		Date:	4/10/11-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4375	PA2 A								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg Prog. rev: PA2 Dwg rev: PA2								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B11-4-13

B11-4-13

B 11.04.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 68449

Wednesday, April 13, 2011 2:54:23 PM



Page 3

Item ID: D4375-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bracket Assembly, LH

Start Date: 4/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

M. L. S. 11-4-15.
Memo
Do not powder coat threaded holes, - MASK threaded holes.

0.00

1 BL 11-4-15.

170 QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 d M. L. S. 11-4-15

180 Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

11-4-18
(14)

M. L. 11/04/18

172 Small fab. INSERT Helicoils

173 QCS - inspect to P&ID only & M. L. S. 11-4-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 68449

Wednesday, April 13, 2011 2:54:23 PM



Page 4

Item ID: D4375-041

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bracket Assembly, LH

Start Date: 4/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/16

MP

11-04-18

POSITIVE RECALL

EFFECTIVE 11-4-13 AUTH

RELEASED DATE 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 2:54:29 PM

Page 1

Work Order ID: 68449

Parent Item: D4375-041

Parent Item Name: Bracket Assembly, LH



Start Date: 4/13/2011

Required Date: 4/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
90296A554  Heli-Coil Insert		Purchased	No				Each	0.0000		3			
M6061T6B0.500X05.00 0		Purchased	No				f	18.0000		0.45			
 6061-T6 Bar .500 x 5.00													

M 117425

SA 11/04/18

11-4-13

Location

MAT004

112154

Loc Qty

18

18

Loc Code

112154

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 68449
Description: BRACKET ASSY LH		Part Number: D4375-1
Inspection Dwg: D4375-1, Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

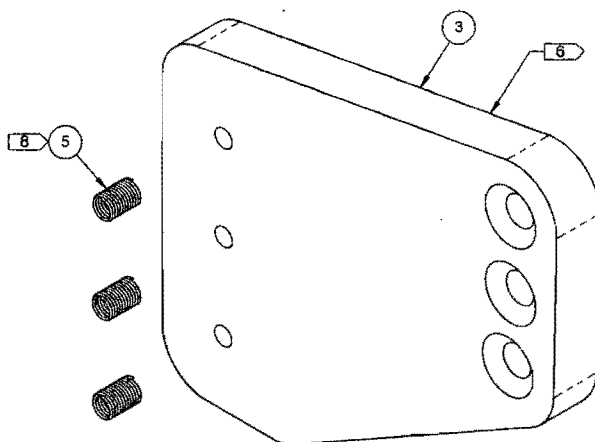
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 323	± .008 - .001	330	✗		V	
.71	± .030	.738	✗		V	1802
4.64	± .030	4.641	✓		V	
4.57	± .030	4.576	✗		V	
.75	± .030	.75	✓		V	
1.75	± .030	1.752	✗		V	
2.75	± .030	2.754	✗		V	
4.18	± .030	4.175	✓		V	
4.07	± .030	4.07	✓		V	
4.61	± .030	4.608	✗		V	

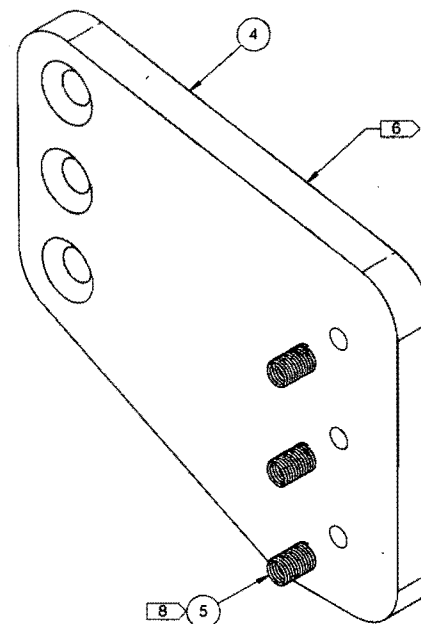
Measured by: B	Audited by: E	Prototype Approval:
Date: 11-4-13	Date: 11.04.14	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4375-041	BRACKET ASSEMBLY, LH
2		X	D4375-043	BRACKET ASSEMBLY, RH
3	1		D4375-1	BRACKET, LH
4		1	D4375-3	BRACKET, RH
5	3	3	90296A554	HELICOIL



D4375-041 BRACKET ASSEMBLY, LH



D4375-043 BRACKET ASSEMBLY, RH

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.26 lbs
 - 8) INSTALL HELICOILS AFTER POWDER COAT

PRELIMINARY ISSUE

11.04.05

PA2	NEW ISSUE	DC	11.04.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

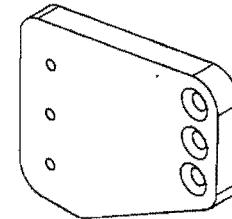
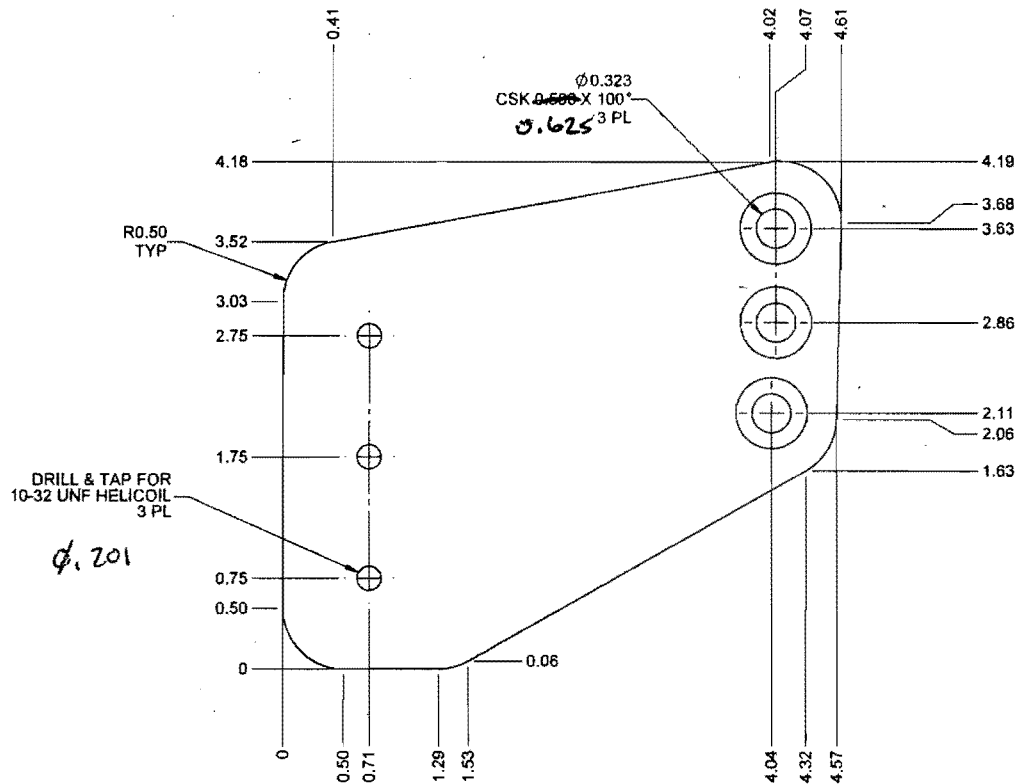
DRAWING NO. **D4375** REV. PA2
SHEET 1 OF 3

TITLE **BRACKET** SCALE **NTS**

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. **68449**

A11-04-B



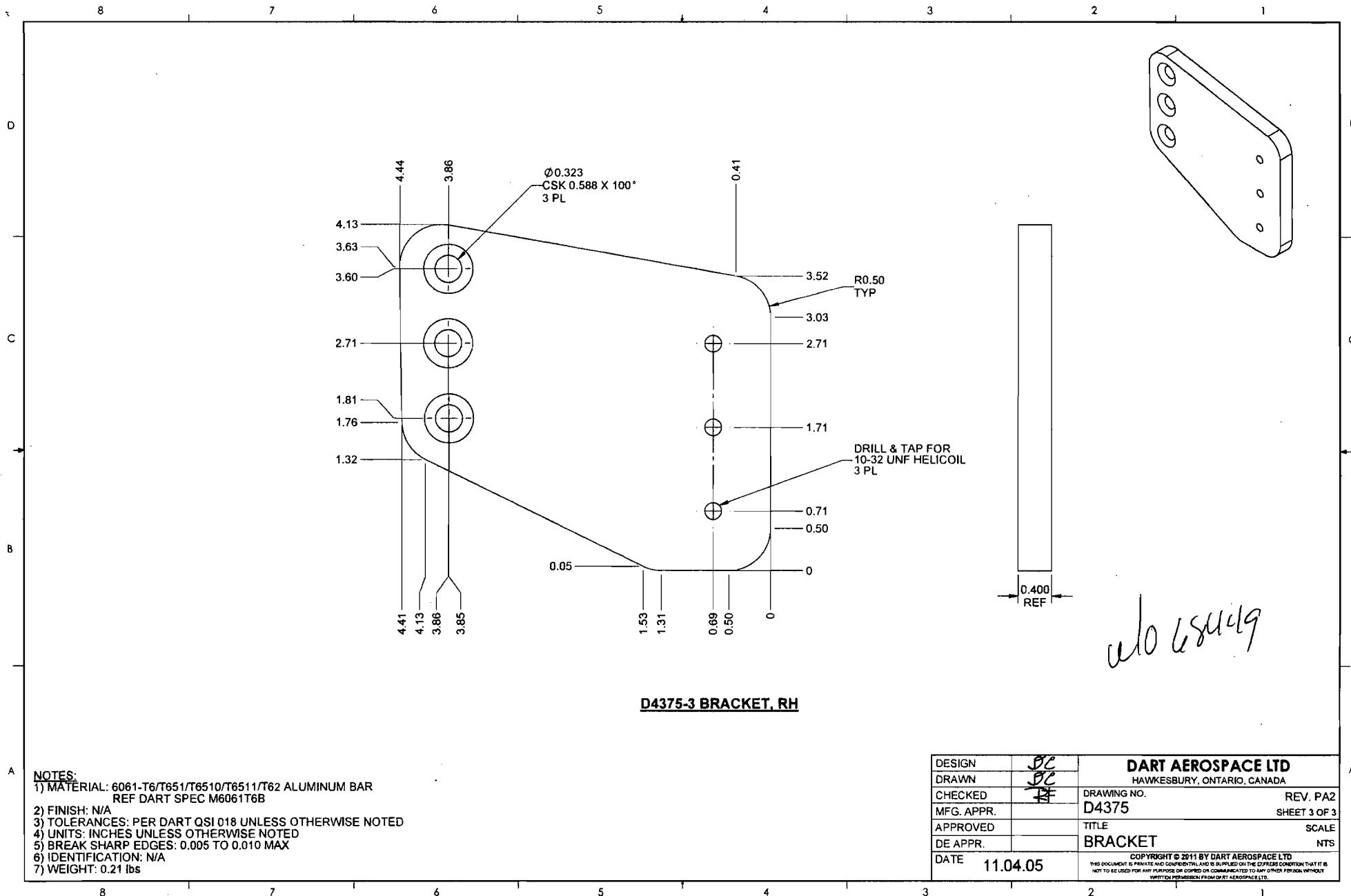
D4375-1 BRACKET, LH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

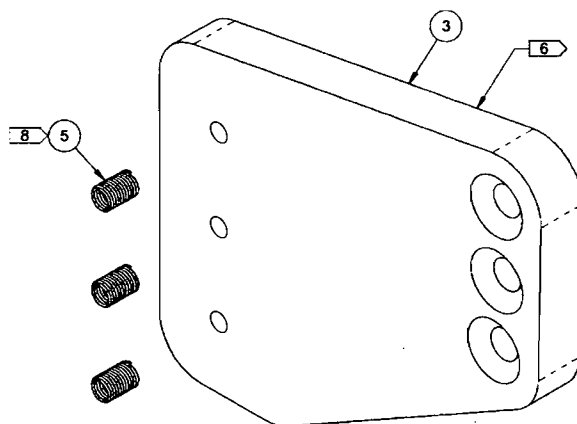
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DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. PA2
MFG. APPR.		D4375	SHEET 2 OF 3
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DE APPR.		BRACKET	NTS
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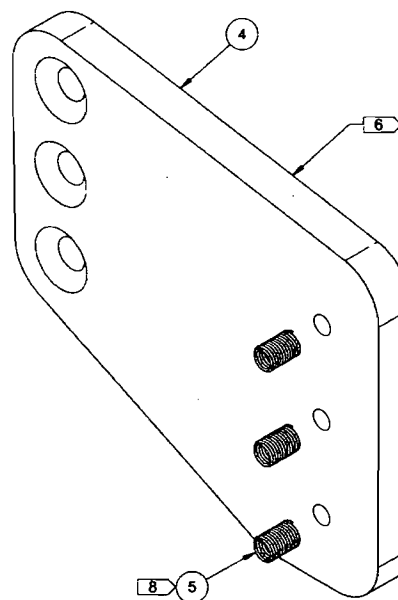


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DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BT	DRAWING NO.	REV. PA2
MFG. APPR.		D4375	SHEET 3 OF 3
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D4375-041 BRACKET ASSEMBLY, LH



D4375-043 BRACKET ASSEMBLY, RH

NOTES:

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POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
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- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) INSTALL HELICOILS AFTER POWDER COAT

A	NEW ISSUE	DC	11.04.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>BC</i>	D4375	SHEET 1 OF 3
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	BRACKET	NTS
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RELEASED
2011-05-18
mw

68449

